

Date: Tuesday, 1/16/2007 11:36:42 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Job Number : 30301	
Estimate Number : 10937	
P.O. Number : N/A	Part Number : D29392 CB
This Issue : 1/16/2007 S.O. No. : N/A	Drawing Number : D2939 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30283	Material : N/A
Written By : <u> </u>	Due Date : 1/30/2007
Checked & Approved By : <u> </u>	Qty : 12 Um : Each
Comment : Est: B 80.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: 325343 07/01/23 12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

 07/01/23 12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

MB 07/02/03 12

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

 07/01/23 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:36:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 30301

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/02/05

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 07/02/05

(12)

7.0

POWDER COATING

POWDER COATING



M1103141



(12X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.h / y

07/02/08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/02/09

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57483

EP 07/02/09

10.0

QC21

FINAL INSPECTION W/O RELEASE



(12)

Comment: FINAL INSPECTION W/O RELEASE

S 07/02/12

Job Completion



U 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30301
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.121	.121	.128		
B	0.100	0.140		.122	.121	.121	.120		
C	0.100	0.140		.110	.115	.122	.123		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.117	.119	.119	.119		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.498	.499	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.259	1.259	1.259	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.01.23

Audited by:	J.L
Date:	07/02/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

DART AEROSPACE LTD	Work Order: 30301
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.121	.121	0.124		
B	0.100	0.140		.121	.121	.121	0.119		
C	0.100	0.140		.123	.123	.173	0.117		
D	0.210	0.230		.220	.220	.228	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515							
I	1.572	1.582		1.577	1.577	1.577	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262	DT8683	.258	.258	.258	0.258		
L	0.312	0.317	DT8686	.314	.314	.314	0.314		
M	0.235	0.240							
N	0.100	0.140		.119	.119	.119	0.121		
O	0.540	0.560		.550	.550	.550	0.551		
P	0.490	0.510		.498	.496	.498	0.502		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.740		
S	0.240	0.270		.252	.252	.252	0.255		
T	0.100	0.180		.140	.140	.178	0.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	0.320		
X	1.250	1.270		1.259	1.259	1.257	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA	Audited by: gmk
Date: 07.01.24 / 07.01.25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	30301
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B		Page 1 of 1

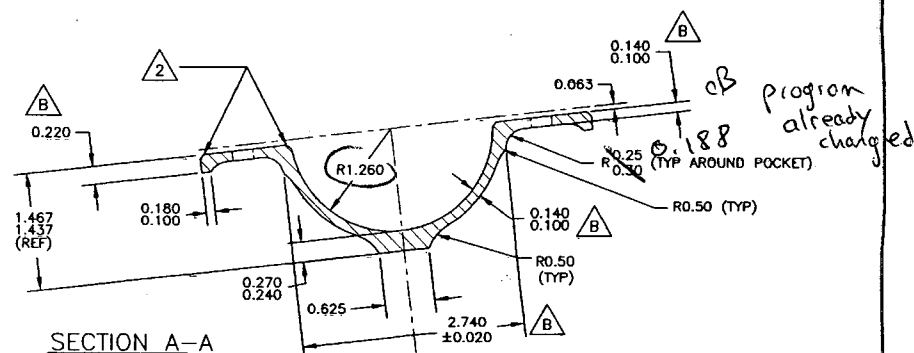
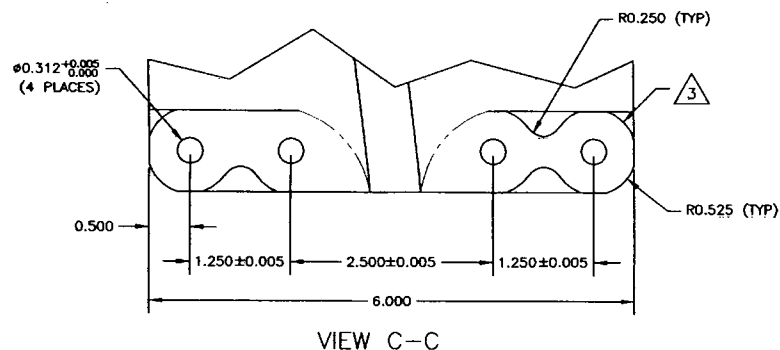
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.123	0.123	0.124	0.123		
B	0.100	0.140		0.121	0.122	0.124	0.124		
C	0.100	0.140		0.119	0.120	0.123	0.120		
D	0.210	0.230		0.221	0.219	0.220	0.220		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.250	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.499	2.499	2.499		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		0.121	0.120	0.121	0.118		
O	0.540	0.560		0.550	0.548	0.550	0.550		
P	0.490	0.510		0.502	0.502	0.502	0.502		
Q	3.715	3.725		3.716	3.716	3.716	3.716		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.251	0.252	0.253	0.253		
T	0.100	0.180		0.140	0.140	0.141	0.141		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.365	1.365	1.365	1.365		
W	0.316	0.321	DT8690	0.319	0.319	0.319	0.319		
X	1.250	1.270		1.255	1.258	1.258	1.259		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.574	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ML
Date:	02/01/25

Audited by:	J.L
Date:	07/02/05

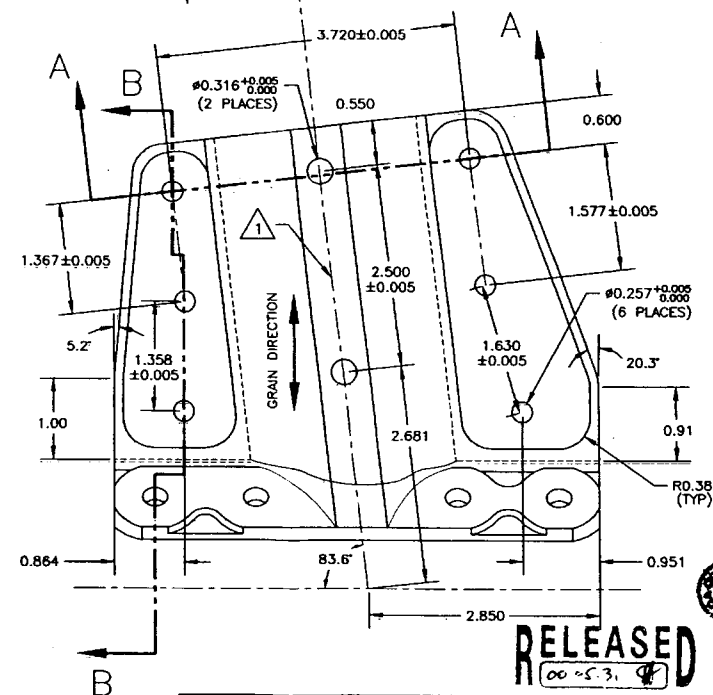
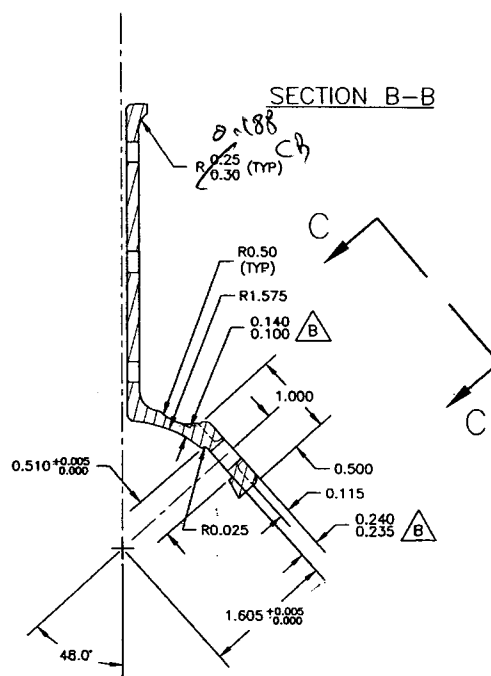
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



UNDER REVIEW
 CB
 change R0.50

NO. 3030
 WORK ORDER
 RETURN TO
 ENGINEERING
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 WITHOUT NOTICE

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 DART AEROSPACE USA, INC.

B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	00.05.29	TITLE SADDLE INSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3